

# Work Order ID 80264

February-15-12 3:35:24 PM

**\*80264\***

Page 1

Item ID: D412-630-034 Accept **\*N900040100\*** Setup Start **\*NS1\***  
 Revision ID: Stop **\*NS2\***  
 Item Name: Heli Access Step RH Folding  
 Start Date: 15/02/2012 Start Qty: 4.00 **\*4\*** Cust Item ID:  
 Required Date: 29/02/2012 Req'd Qty: 4.00 **\*4\*** Customer:  
 Reference:

Approvals: Process Plan: M. L. J Date: 12/02/12 Tooling: Date: Run Start **\*NR1\***  
 QC: Date: SPC (Y/N): Date: Stop **\*NR2\***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

Draw Nbr	Revision Nbr
IIN D412-630	Rev M

100  
**\*100\***  
 DC  
 Document Control

DOCUMENT CONTROL  
 Memo  
 Photocopy bluefile & create labels per PPP D412-630-034 CHG003

0.00  
 0.00

*6 812/04/04*

*MLJ 12-4-4 (3)*

110  
**\*110\***  
 Small Fab  
 Small Fab

Small Fab  
 Memo  
 Assemble as per dwg D412-630 p.14  
 Coat all hardware with LPS3 rust inhibitor  
 A/R LPS3 batch: M119317  
 COAT exposed HARDWARE WITH LPS PROCYON  
 A/R LPS PROCYON BATCH: M114596

0.00  
 0.00

*812/04/04 (3)*

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

# Work Order ID 80264

**\*80264\***

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Item ID: D412-630-034

Accept

**\*N900040100\***

Setup Start **\*NS1\***

Revision ID:

Item Name: Heli Access Step RH Folding

Stop **\*NS2\***

Start Date: 15/02/2012 Start Qty: 4.00

**\*4\***

Cust Item ID:

Required Date: 29/02/2012 Req'd Qty: 4.00

**\*4\***

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start **\*NR1\***

QC:

Date:

SPC (Y/N):

Date:

Stop **\*NR2\***

Sequence ID/  
Work Center ID

Operation  
Description

Set Up/  
Run Hours

Tool ID

Tool #

Plan  
Code

Accept  
Qty

Reject  
Qty

Reject  
Number

Insp.  
Stamp

120

QC5- Inspect part completeness to step on W/O

0.00

**\*120\***

QC

Memo

0.00

Quality Control

130

Pick Kit

0.00

**\*130\***

Packaging

Memo

0.00

Packaging

140

QC4- 100% Inspect kits for completeness

0.00

**\*140\***

QC

Memo

0.00

Quality Control

83  
RH

90

12/04/04

83  
RH

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

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**Work Order ID 80264****\*80264\***

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Item ID: D412-630-034

Accept

**\*N900040100\***Setup Start **\*NS1\***

Revision ID:

Item Name: Heli Access Step RH Folding

Stop **\*NS2\***

Start Date: 15/02/2012 Start Qty: 4.00

**\*4\***

Cust Item ID:

Required Date: 29/02/2012 Req'd Qty: 4.00

**\*4\***

Customer:

Reference:

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_

Run Start **\*NR1\***

QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Stop **\*NR2\***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

150

0.00

**\*150\***

Packaging

Packaging

Memo

0.00

Identify and pack for shipping as per PPP D412-630-034

Location: 111

PPP Rev: \_\_\_\_\_

160

0.00

**\*160\***

QC

QC21- Final Inspection - Work Order Release

Memo

0.00

Quality Control

*12/4/4**12/4/5**112-04-5*

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Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

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Work Order ID: 80264

\*80264\*

Parent Item: D412-630-034

\*D412-630-034\*

Parent Item Name: Heli Access Step RH Folding

Start Date: 15/02/2012

Required Date: 29/02/2012

Start Qty: 4.00

Required Qty: 4.00

Comments: IPP Rev:A New Issue 06-11-08 JLM  
IPP rev B ecn1019, added D2807-041 EC verified by:DD  
IPP rev :C 11.01.06 added route seq ID DD vef:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
AN310C8 <b>*AN310C.8*</b> Nut		Purchased	No			110	Each	32.0000	2	8		12/04/04	**
				<u>Location</u>			<u>Loc Qty</u>			<u>Loc Code</u>			
				ST344			32						
					118378		2						
					120308		20						
					120644		10						
AN3C21A <b>*AN3C21A*</b> BOLT		Purchased	No			110	Each	66.0000	2	8		12/04/04	**
				<u>Location</u>			<u>Loc Qty</u>			<u>Loc Code</u>			
				ST352			66						
					109148		2						
					117514		14						
					119798		50						
AN8C16 <b>*AN8C.16*</b> Bolt		Purchased	No			110	Each	36.0000	2	8		12/04/04	**
				<u>Location</u>			<u>Loc Qty</u>			<u>Loc Code</u>			
				ST343			36						
					106066		2						
					118451		14						
					120578		20						

M120748  
(4X)

**Dart Aerospace Ltd**

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_  
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Parent Item Name: Heli Access Step RH Folding

\*80264\*

\*D412-630-034\*

Start Date: 15/02/2012

Required Date: 29/02/2012

Start Qty: 4.00

Required Qty: 4.00

D2012-107 Manufactured No

110 Each 31.0000 1 4

\*D2012-107\*

Clevis

\*\*

Location

Loc Qty

Loc Code

ST004

31

71602

1

75057

30

D2803-042 Manufactured No

110 Each 2.0000 1 4

\*D2803-042\*

Bracket Assembly

\*\*

Location

Loc Qty

Loc Code

ST149

2

79522

2

D2804-042 Manufactured No

110 Each 2.0000 1 4

\*D2804-042\*

Bracket Assembly

\*\*

Location

Loc Qty

Loc Code

ST148

1

79185

1

ST150

1

76183

1

D2807-041 Manufactured No

110 Each 15.0000 2 8

\*D2807-041\*

Door prop

\*\*

Location

Loc Qty

Loc Code

ST018

15

60540

2

68494

5

79007

8

ES 12/04/04

ES 12/04/04

B80258 (3x)

ES 12/04/04

B80255 (1x)

ES 12/04/04

B81995

(2x)

B80165 (4x)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

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\*80264\*

Parent Item: D412-630-034

\*D412-630-034\*

Parent Item Name: Heli Access Step RH Folding

Start Date: 15/02/2012

Required Date: 29/02/2012

Start Qty: 4.00

Required Qty: 4.00

D2813 Manufactured No

110 Each 41.0000 2 8

\*D2813\*

Washer

\*\*

*EP 12/04/04*

Location

Loc Qty

Loc Code

ST018

41

69386

1

79691

40

D3395-1 Manufactured No

110 Each 33.0000 4 16

\*D3395-1\*

Bushing

\*\*

*EP 12/04/04*

Location

Loc Qty

Loc Code

ST041

33

71563

13

78840

20

D3562-042 Manufactured No

110 Each 0.0000 1 4

\*D3562-042\*

Step Assembly, RH

\*\*

*B80266 (3x)*

*EP 12/04/04*

*B81118 (12x)*

**Dart Aerospace Ltd**

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

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Work Order ID: 80264

\*80264\*

Parent Item: D412-630-034

\*D412-630-034\*

Parent Item Name: Heli Access Step RH Folding

Start Date: 15/02/2012

Required Date: 29/02/2012

Start Qty: 4.00

Required Qty: 4.00

MS21043-3 Purchased No

110 Each 1,340.000 4 16

\*MS21043-3\*

Nut

\*\*

Location	Loc Qty	Loc Code
FG	72	
103691	72	
GA	400	
120693	400	
ST300	373	
119901	373	
ST301	495	
118077	2	
118614	441	
118686	30	
119758	22	

*EP 12/04/04*

*12*

MS24665-302 Purchased No

110 Each 245.0000 2 8

\*MS24665-302\*

Cotter Pin

\*\*

Location	Loc Qty	Loc Code
ST309	245	
117460	45	
120521	200	

*EP 12/04/04*

*4*

*M120512 (2x)*

MS24693-C280 Purchased No

110 Each 53.0000 2 8

\*MS24693-C280\*

Screw

\*\*

Location	Loc Qty	Loc Code
ST289	25	
120498	25	
ST310	28	
118612	28	

*EP 12/04/04*

*4*

*M121060 (2x)*

**Dart Aerospace Ltd**

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_  
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Work Order ID: 80264

Parent Item: D412-630-034

Parent Item Name: Heli Access Step RH Folding

\*80264\*

\*D412-630-034\*

Start Date: 15/02/2012

Required Date: 29/02/2012

Start Qty: 4.00

Required Qty: 4.00

NAS1515H3

Purchased

No

110

Each

286.0000

6

24

\*\*

\*NAS1515H3\*

Washer

Location

Loc Qty

Loc Code

ST277

286

118078

6

118384

11

119438

4

120142

99

120518

166

NAS1515H5L

Purchased

No

110

Each

130.0000

4

16

\*\*

\*NAS1515H5I \*

WASHER

Location

Loc Qty

Loc Code

FG

40

103691

40

ST277

90

119902

90

NAS1515H8

Purchased

No

110

Each

99.0000

4

16

\*\*

\*NAS1515H8\*

Washer

Location

Loc Qty

Loc Code

ST277

99

111275

4

111411

95

AN44C7A

Purchased

No

130

Each

32.0000

\*\*

\*AN44C7A\*

Eyebolt

Location

Loc Qty

Loc Code

ST362

32

111308

32

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Shop Packet Print

Page 5

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

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Work Order ID: 80264

\*80264\*

Parent Item: D412-630-034

\*D412-630-034\*

Parent Item Name: Heli Access Step RH Folding

Start Date: 15/02/2012

Required Date: 29/02/2012

Start Qty: 4.00

Required Qty: 4.00

AN4C10A

Purchased

No

130

Each

40.0000

\*AN4C10A\*

Bolt

\*\*

1 4 3 4  
120820 JB



Location

Loc Qty

Loc Code

ST356

40

112243

10

114523

30

130

Each

283.0000

\*\*

2 8 6 ✓

JB



AN4C15A

Purchased

No

\*AN4C15A\*

Bolt

Location

Loc Qty

Loc Code

ST358

283

115835

2

118706

81

120360

200

130

Each

606.0000

\*\*

1 4 3 ✓

JB

12/04/04



AN4C6A

Purchased

No

\*AN4C6A\*

Bolt

Location

Loc Qty

Loc Code

FG

4

103344

4

ST356

602

116704

8

119328

94

119749

200

120423

200

120521

100

120521

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

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\*80264\*

Parent Item: D412-630-034

\*D412-630-034\*

Parent Item Name: Heli Access Step RH Folding

Start Date: 15/02/2012

Required Date: 29/02/2012

Start Qty: 4.00

Required Qty: 4.00

AN5C15A

Purchased

No

130

Each

71.0000

\*AN5C15A\*

Bolt

2 8 6 ✓  
\*\* 24120833 JB

Location

Loc Qty

Loc Code

ST338

71

118191

3

118267

13

119749

25

120422

30

47119749

D2806-1

Manufactured

No

130

Each

43.0000

\*D2806-1\*

Bushing

2 8 6 ✓  
\*\* JB

Location

Loc Qty

Loc Code

ST018

43

78888

18

79527

25

D2806-3

Manufactured

No

130

Each

32.0000

\*D2806-3\*

Bushing

2 79527 8 6 ✓  
\*\* 20

Location

Loc Qty

Loc Code

ST018

32

76187

7

79528

25

D2810-5

Manufactured

No

130

Each

5.0000

\*D2810-5\*

Strut

1 79528 23 ✓  
\*\* 2X 81072 JB 12/04/04  
1X 79690

Location

Loc Qty

Loc Code

ST265

5

52034

1

78917

4

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

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Parent Item: D412-630-034

\*D412-630-034\*

Parent Item Name: Heli Access Step RH Folding

Start Date: 15/02/2012

Required Date: 29/02/2012

Start Qty: 4.00

Required Qty: 4.00

D3396-1

Manufactured No

130 Each

32.0000

\*D3396-1\*

Spacer

\*\*

Location

Loc Qty

Loc Code

ST041

32

78885

32

Purchased

No

130

Each

1,773.000

MS21043-4

\*MS21043-4\*

Nut

\*\*

Location

Loc Qty

Loc Code

FG

40

104603

40

ST300

288

118686

288

ST301

1445

119546

445

120308

1000

Purchased

No

130

Each

547.0000

MS21043-5

\*MS21043-5\*

Nut

\*\*

Location

Loc Qty

Loc Code

FG

20

101418

20

ST300

102

112314

102

ST301

425

116548

100

118159

100

119307

25

119537

200

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

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**\*80264\***

Parent Item: D412-630-034

**\*D412-630-034\***

Parent Item Name: Heli Access Step RH Folding

Start Date: 15/02/2012

Required Date: 29/02/2012

Start Qty: 4.00

Required Qty: 4.00

NAS1515H4

Purchased

No

130

Each

179.0000

**\*NAS1515H4\***

Washer

\*\*

7 28 21 ✓

12/060

9 B

Location

Loc Qty

Loc Code

ST277

179

116169

3

117460

1

117735

3

118078

48

118612

9

120120

50

120498

65

NAS1515H5

Purchased

No

130

Each

298.0000

**\*NAS1515H5\***

Washer

\*\*

7 28 21 ✓

2 B

Location

Loc Qty

Loc Code

FG

25

103286

5

103691

20

GA

100

120449

100

ST277

173

120299

73

120304

100

120304

12/04/04

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

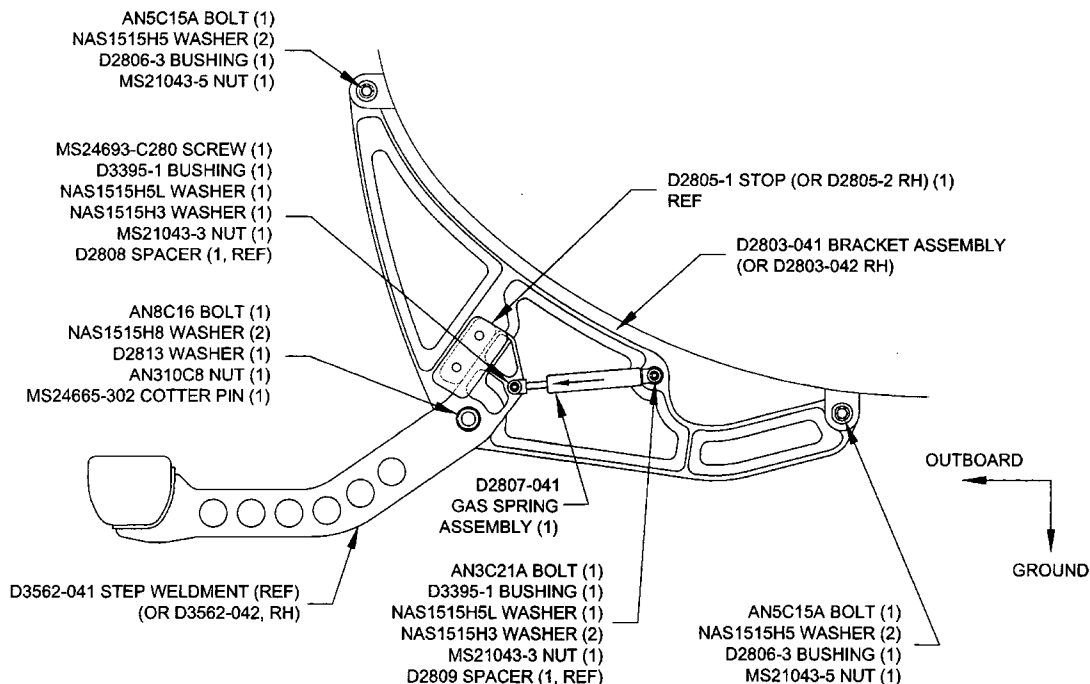
Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

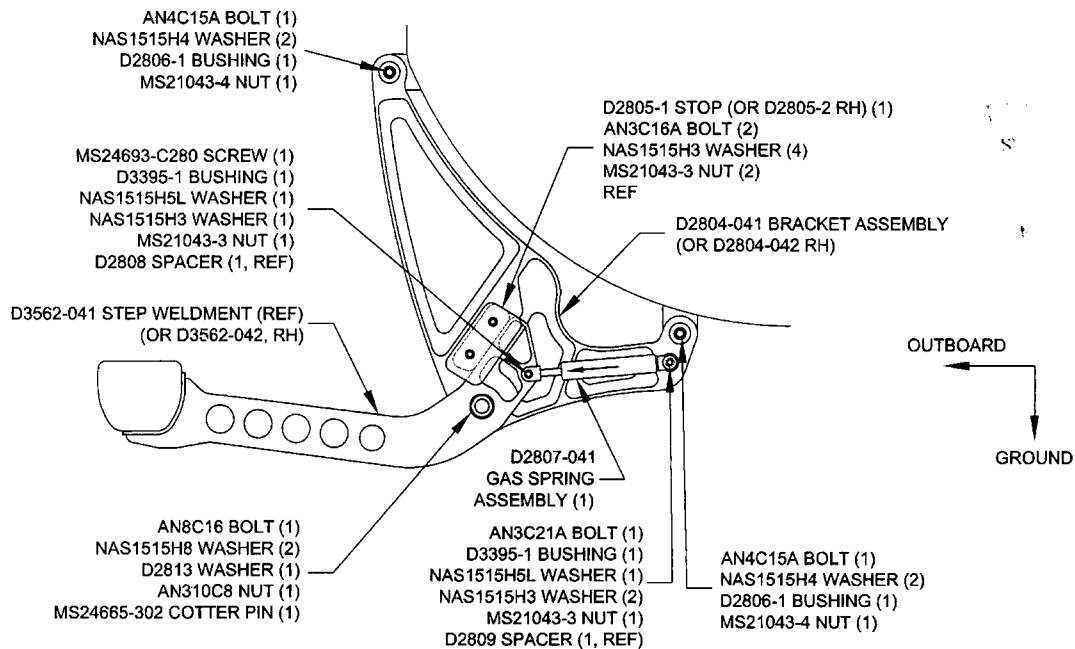
NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries



**D412-630-033/-034 Heli-Access-Step™ Installation**

**FIGURE 14 – STA 84.29 for D412-630-033/-034 Heli-Access-Step™ Installation**  
(View rotated 90° CW)



**FIGURE 15 – STA 155.06 for D412-630-033/-034 Heli-Access-Step™ Installation**  
(View rotated 90° CW)

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Revision: **M**  
Date: 08.12.12

80264  
M.C.J  
12/02/16

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

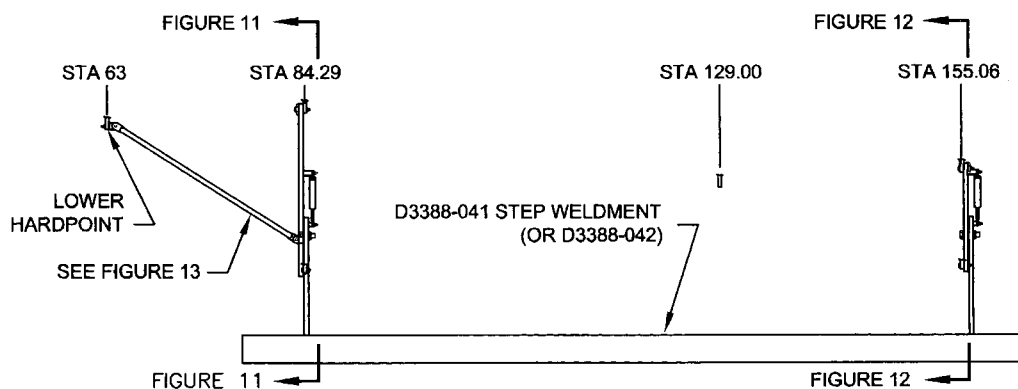
Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

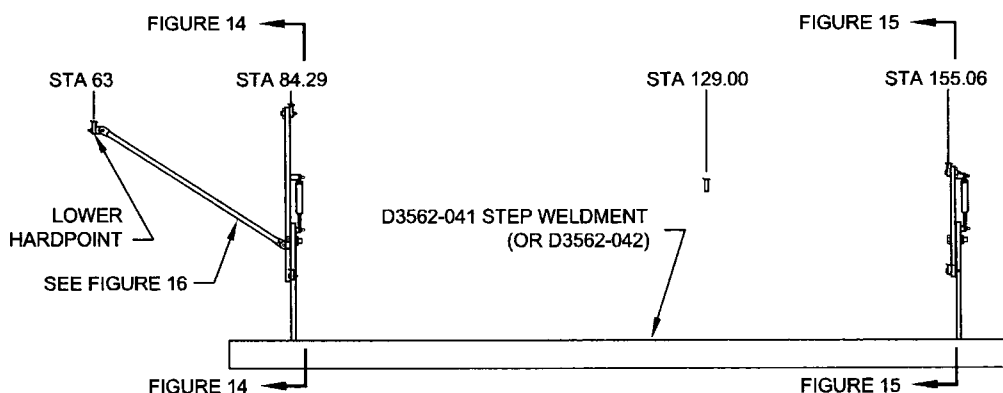
NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

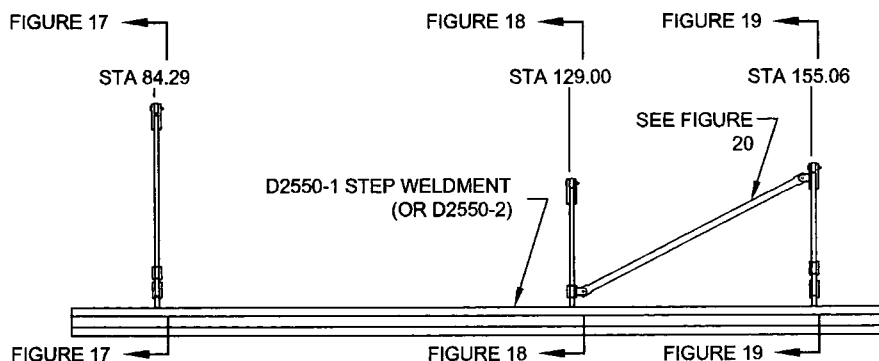
**D412-630-023 HELI-ACCESS-STEP™ LH, FOLDING (SHOWN)**  
**D412-630-024 HELI-ACCESS-STEP™ RH, FOLDING (OPPOSITE)**



**D412-630-033 HELI-ACCESS-STEP™ LH, FOLDING (SHOWN)**  
**D412-630-034 HELI-ACCESS-STEP™ RH, FOLDING (OPPOSITE)**



**D412-630-111 HELI-ACCESS-STEP™ LH, HEAVY DUTY FIXED (SHOWN)**  
**D412-630-112 HELI-ACCESS-STEP™ RH, HEAVY DUTY FIXED (OPPOSITE)**



**FIGURE 3 – D412-630 Heli-Access-Step™ Installations**

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Qty -033	Qty -034	Qty -243	Qty -244	Part Number	Description
X	X			D412-630-033	HELI-ACCESS-STEP™ LH (FOLDING)
	X			D412-630-034	HELI-ACCESS-STEP™ RH (FOLDING)
1		X		D412-630-243	STEP ASSEMBLY LH
	1		X	D412-630-244	STEP ASSEMBLY RH
		1	1	D2012-107	CLEVIS
		1		D2803-041	STA 84 BRACKET ASSEMBLY LH
			1	D2803-042	STA 84 BRACKET ASSEMBLY RH
		1		D2804-041	STA 155 BRACKET ASSEMBLY LH
			1	D2804-042	STA 155 BRACKET ASSEMBLY RH
/ 2	2			D2806-1	BUSHING
/ 2	2			D2806-3	BUSHING
		2	2	D2807-041	GAS SPRING ASSEMBLY (WAS D2807)
/ 1	1			D2810-5	STRUT
		2	2	D2813	WASHER
		1		D3562-041	STEP WELDMENT LH
			1	D3562-042	STEP WELDMENT RH
		4	4	D3395-1	BUSHING
/ 2	2			D3396-1	SPACER
		2	2	AN3C21A	BOLT
/ 1	1			AN4C6A	BOLT
/ 1	1			AN4C10A	BOLT
2	2			AN4C15A	BOLT
1	1			AN44C7A	EYEBOLT
2	2			AN5C15A	BOLT
		2	2	AN8C16	BOLT
		2	2	AN310C8	NUT
		2	2	MS24665-302	COTTER PIN (OR AN380C3-4)
		6	6	NAS1515H3	WASHER
7	7			NAS1515H4	WASHER
7	7			NAS1515H5	WASHER
		4	4	NAS1515H5L	WASHER
		4	4	NAS1515H8	WASHER
		4	4	MS21043-3	NUT
/ 4	4			MS21043-4	NUT
/ 3	3			MS21043-5	NUT
		2	2	MS24693-C280	SCREW (OR MS24694-C565)

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